

Date: Tuesday, 09/10/2007 2:55:19 PM
User: Linda Lacelle

Process Sheet

Split #1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 35032 - 1		
Estimate Number	: 12884		
P.O. Number	: N/A	Part Number	: D3560044
This Issue	: 09/10/2007 S.O. No. : N/A	Drawing Number	: D3560 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: 35032	Material	: N/A
Written By	: <u> </u>	Due Date	: 19/10/2007
Checked & Approved By	: <u> </u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 07.05.24 EC Est Rev B ECN 987 07.10.09 EC verified by DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
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Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: 3105950

SC 07.10.29

(10)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 15.500" long

SC 07.10.29

(10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

SC 07.10.29

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SC 07.10.29

(10)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 07/10/29

up's

su

Date: Tuesday, 09/10/2007 2:55:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35032

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

PLATE 335331

PL 07.12.13

4

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

PL 07.12.13

4

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (609)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

PL 07.12.13

4

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PL 07.12.13 (4)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 07.12.13 (4)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07.12.13

(4)

Date: Tuesday, 09/10/2007 2:55:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35032

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-12-13

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

batch:

B 35330

(4)

mf 07-12-13

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

mf. 07-12-13 (4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 07-12-13 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *mf*

mf 07-12-13 4

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)
mf 07-12-13

Job Completion



mf 07-12-13

Date: Friday, 10/5/2007 10:58:45 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 35032		
Estimate Number	: 12884		
P.O. Number	:	Part Number	: D3560044
This Issue	: 10/5/2007 S.O. No. :	Drawing Number	: D3560 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: <i>BC</i>
Previous Run	: 34967	Material	:
Written By	:	Due Date	: 10/19/2007 Qty: 10 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07.05.24 EC		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: _____

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks 15.500" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: _____ & Dwg D3560 Rev: _____

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35032

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
PLATE

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35032
Description: Arm		Part Number:	D3560-4
Inspection Dwg: D3560	Rev: <i>KL</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	✓			
Ø0.196	+0.005/-0.001	.197	✓			
Ø1.000	+0.010/-0.001	1.005	✓			
Ø0.900	+0.010/-0.001	.900	✓			
0.500	+/-0.010	.496	✓			
0.250	+/-0.010	.248	✓			
0.275	+/-0.010	.276	✓			
0.188	+/-0.010	.192	✓			
2.000	+/-0.010	2.000	✓			
1.750	+/-0.010	1.750	✓			
1.702	+/-0.010	1.705	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380x100°	✓			
0.250 Deep	+/-0.010	.248	✓			

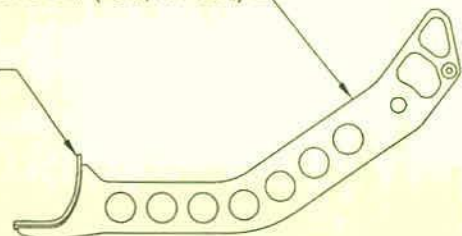
Measured by: <i>JSK</i>	Audited by: <i>J.L</i>	Prototype Approval:	N/A
Date: <i>02.10.29</i>	Date: <i>07/10/29</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM <i>KL</i>	<i>KL</i>

14

D3560-1 ARM (-041, SHOWN)
OR D3560-2 ARM (-042, OPPOSITE)

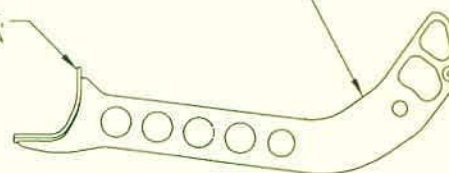
D3592-1 PLATE,
SEE DETAIL A



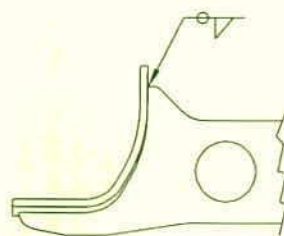
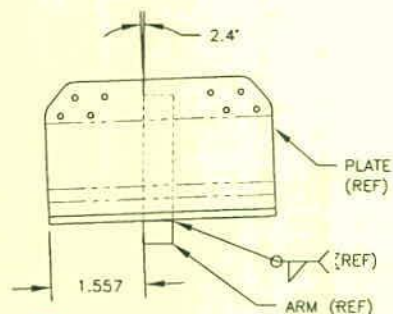
D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.24

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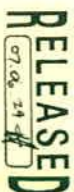
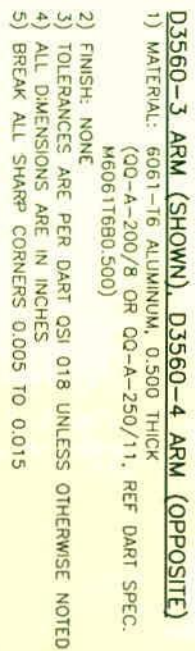
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DART AEROSPACE LTD.

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qf	DRAWN BY qf
CHECKED	qf	APPROVED qf
DATE	07.06.19	TITLE
		ARM WELDMENT
		SCALE
		1:4

DART DART AEROSPACE LTD.
WARRICK, ONTARIO, CANADA

DRAWING NO. D3560 REV. C
SHEET 1 OF 3

NO. 35032
WORK ORDER
SUBJECT TO AGREEMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



NO. 35032
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

WORK ORDER NO. 35032

